

Wednesday, March 04, 2015 7:55:21 AM

Page 1

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LD 15-3-16

4 9 15-3-16 DEL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130288

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130288

Page 2

Item ID: D3507-1-BENT Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube Assembly EC135
Start Date: 3/4/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/4/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

MLJ 1503-17

MS-3-17

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Picklist Print

Wednesday, March 04, 2015 7:55:25 AM

Page 1

Work Order ID: 130288

130288

Parent Item: D3507-1-BENT

D3507-1-BENT

Parent Item Name: Skidtube Assembly EC135

Start Date: 3/4/2015

Required Date: 3/4/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150		Manufactured	No			100	Each	17.0000	1	4			

D2962-150

3.540 Outer Tube, Extrud

Location

Loc Qty

Loc Code

HALL

17

90871

17

4 DGL 15-3-16.

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Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3508-1	DOUBLER
2	D3508-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C-1032-10	SCREW
33	AN960C-10L	WASHER
12	MS20601AD4W3	RIVET

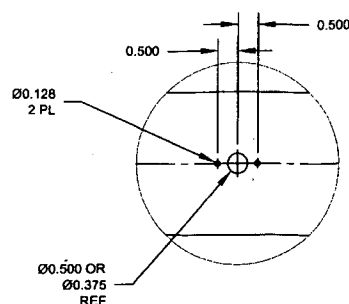
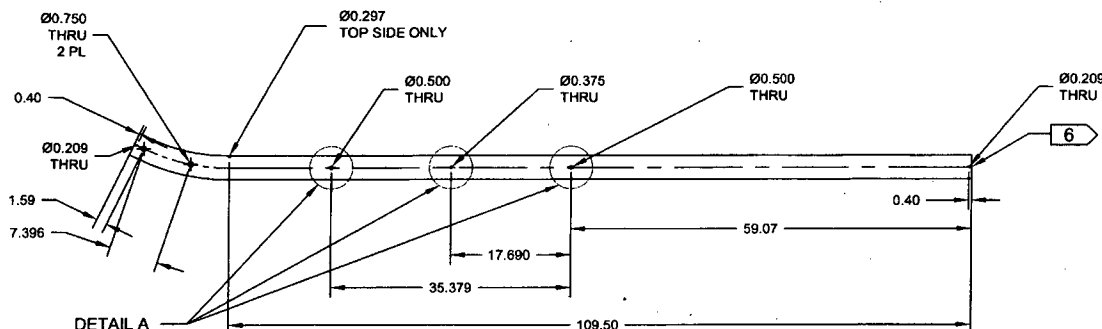
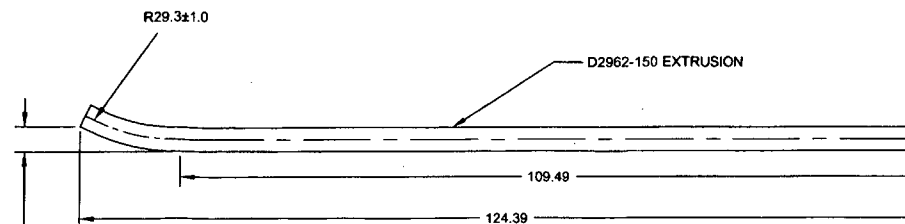
GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 8.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- WEIGHT: 24.1 LB (FROM IIN-D135-751)
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

SHOW

REF

130288 MJS
15-03-04



D	REMOVE D3558-X GASKETS. D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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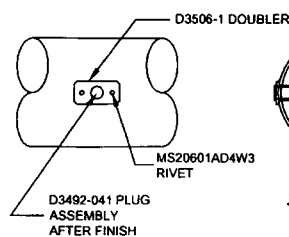
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Transport									
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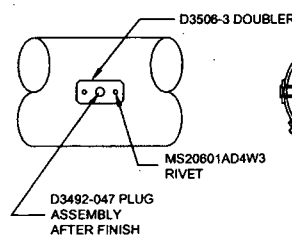
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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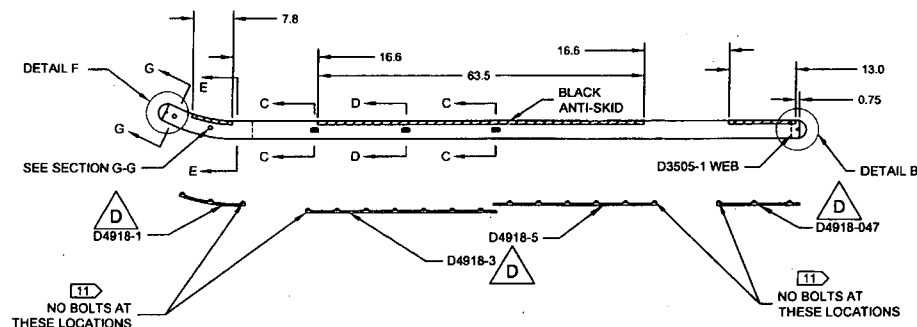
SECTION C-C
(SCALE 3:10)

- D3504-1 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (Y" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

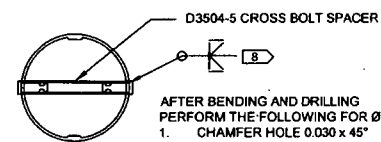


SECTION D-D
(SCALE 3:10)

- D3504-3 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (J" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL

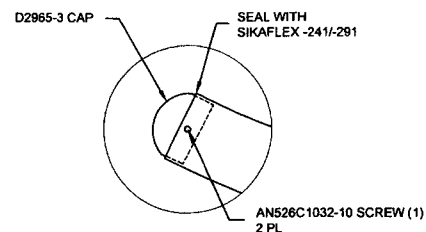


D3507-041 ASSEMBLY DETAIL

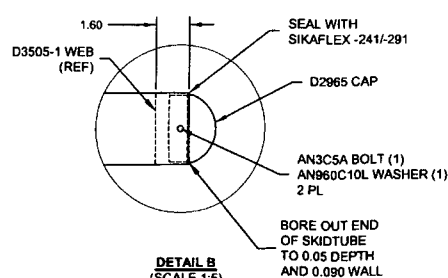


SECTION G-G
(SCALE 3:10)

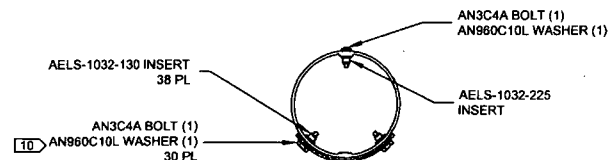
- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



DETAIL F
(SCALE 1:5)



DETAIL B
(SCALE 1:5)



SECTION E-E
(SCALE 3:10)

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	GP	D3507	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-12-10

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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